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8. TEST PROCEDURE SHEET

	Accumulator incoming & outgoing inspection		company: AIDC		date: 30/12/2008	
	Fill in by hand.		engineer: Raki Huang		location: J2303	
Step	Action	Monitoring	Value	Result	Comment	✓
1.	Record test equipment in appendix 1					
2.	Record inspection type (is it incoming or outgoing?)		Incoming /outgoing	Incoming		✓
3.	Component comes from	origin		SYSU		✓
4.	Component goes to	destination		AIDC		✓
5.	Part number					

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Accumulator incoming & outgoing inspection		company:		date:		
Fill in by hand.		engineer:		location:		
Step	Action	Monitoring	Value	Result	Comment	✓
6.	Serial number					
7.	Record model type		QM /FM	QM	Used for TTCB-FMP Box afterwards	✓
8.	Visual inspection, unaided eye, look at outer surface for - scratches - dents	scratches dents fitting				
9.	Take pictures of the accumulator from all sides					
10.	Accumulator dimension check (Write the measured values in the Appendix drawings)		TTCB0100_2; ET5998-07; TTCB0100_3			
11.	Clamp dimension check (Write the measured values in the Appendix drawings)		TTCB010201			
12.	Slide dimension check (Write the measured values in the Appendix drawings)		TTCB010501			

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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	✓
13.	Check the bolt types					
14.	Check the torque of Clamp Bracket-Collar bolts (NAS1351N08-14)		22.8 In*lb -26.9 In*lb			
15.	Check the torque of Pipe Fix-Clamp bolts (NAS1351N06-10)		13.3 In*lb -15.7 In*lb			
16.	Check the torque of Press-Saddle bolts (NAS1351N08-12)		22.8 In*lb -26.9 In*lb			
17.	Check the heater resistance					
	1. Resistance of FAC_a	Resistance	20.9±1 Ω	21.7 Ω		✓
	2. Resistance of FAC_b	Resistance	20.9±2 Ω	21.6 Ω		✓
18.	Check the electric insulation of heater					
	1. Electric insulation of FAC_a	Resistance	>20Mohm	OPEN		✓

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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	✓
	2. Electric insulation of FAC_b	Resistance	>20Mohm	OPEN		✓
19.	Check the Peltier element resistance					
	1. Resistance of Peltier element 1	Resistance	3.4±1Ohm@25℃	4.6Ω		✓
	2. Resistance of Peltier element 2	Resistance	3.4±1Ohm@25℃	4.7Ω		✓
	3. Resistance of Peltier element 3	Resistance	3.4±1Ohm@25℃	4.6Ω		✓
	4. Resistance of Peltier element 4	Resistance	3.4±1Ohm@25℃	4.5Ω		✓
20.	Check the electric insulation of Peltier element					
	1. Electric insulation of Peltier element 1	Resistance	>20Mohm	OPEN		✓
	2. Electric insulation of Peltier element 2	Resistance	>20Mohm	OPEN		✓

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	Accumulator incoming & outgoing inspection		company:		date:	
	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	✓
	3. Electric insulation of Peltier element 3	Resistance	>20Mohm	OPEN		✓
	4. Electric insulation of Peltier element 4	Resistance	>20Mohm	OPEN		✓
21.	He leak test: Measure equipment background level (put cap on tester, without test item being connected)	Background Leak Rate	$<2*10^{-10}$ mbar.l/s	$<1 \times 10^{-10}$ mbar.l/s		✓
22.	He leak test: Connect test item and measure leak rate value without spraying helium	Leak Rate	$<2*10^{-10}$ mbar.l/s	$<1 \times 10^{-10}$ mbar.l/s		✓
23.	He leak test: Connect test item and cover it with a plastic bag and measure and record the leak rate value when the plastic bag is filled with helium	Leak Rate	$<1*10^{-9}$ mbar.l/s	$<1 \times 10^{-10}$ mbar.l/s		✓
24.	Disconnect the accumulator liquid pipe from the leak tester					✓
25.	He leak test: Measure equipment background level (put cap on tester, without test item being connected)	Background Leak Rate	$<2*10^{-10}$ mbar.l/s	$<1 \times 10^{-10}$ mbar.l/s		✓
26.	He leak test: Connect test item and measure leak rate value without spraying helium	Leak Rate	$<2*10^{-10}$ mbar.l/s	$<1 \times 10^{-10}$ mbar.l/s		✓

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	Fill in by hand.		engineer:		location:	
Step	Action	Monitoring	Value	Result	Comment	✓
27.	He leak test: Connect test item and cover it with a plastic bag and measure and record the leak rate value when the plastic bag is filled with helium	Leak Rate	$< 1 \times 10^{-9}$ mbar.l/s	$< 1 \times 10^{-10}$ mbar.l/s		✓
28.	Disconnect the Peltier pipe from the leak tester					✓
	End of sheet					

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9. APPENDIX 1 TEST EQUIPMENT

Test equipment	Manufacturer and type	Calibration / functional check	
		Date	Next Date
Multimeter	Agilent 34401A	07/24/2008	07/24/2009

10. APPENDIX 2 ACCUMULATOR DRAWINGS

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